

304 500 X .049W

Work Order ID 85917

\*85917\*

Page 1

June-18-12 2:16:04 PM

Item ID: D4425-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Step Spacer

Start Date: 18/06/2012 Start Qty: 26.00

\*26\*

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 26.00

\*26\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/18

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4425

A

100

0.00

\*100\*

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per folio FB062 AND DWG

DWG REV: FA

FOLIO REV: FA

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

2 2 6 19 26 4

29 2 2 19 26 4

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85917

June-18-12 2:16:04 PM

**\*85917\***

Page 2

Item ID: D4425-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Step Spacer

Stop

**\*NS2\***

Start Date: 18/06/2012 Start Qty: 26.00

**\*26\***

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 26.00

**\*26\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

*12/6/19*

*26*

Quality Control

130

Identify as per dwg & Stock Location: *mm*

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

\*\*\*STOCK IN SKIDTUBE CELL\*\*\*

*26*

*12-06-19*

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*12/6/20*  
*12-06-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

June-18-12 2:16:08 PM

Page 1

Work Order ID: 85917

\*85917\*

Parent Item: D4425-1

\*D4425-1\*

Parent Item Name: Step Spacer

Start Date: 18/06/2012

Required Date: 02/07/2012

Start Qty: 26.00

Required Qty: 26.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049		Purchased	No			100	f	192.9011	0.25	6.842105			

\*M304TR0 500W 049\*

304 RD Tube .500 x .049W

\*\*

22.6.19

## Location

## Loc Qty

## Loc Code

MAT017

192.90111

111814

2.23

115010

109.254058

117598

1.47

119087

7.359

120633 ✓

72.588052

6-5

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

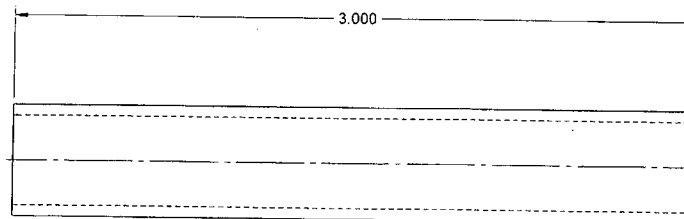
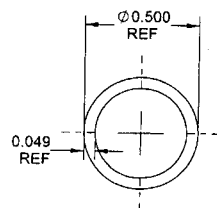
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**NOTE:** Date & initial all entries



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85917 MLJ  
12/06/10

D4425-1 STEP SPACER



D4425-1 STEP SPACER

RELEASED  
2011-07-28  
ANT

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING,  $\phi 0.500 \times 0.049$  WALL  
PER ASTM A213 OR ASME SA213 OR ASTM A269  
REF M304TR0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

A		NEW ISSUE		DESCRIPTION		AJS	11.07.06
REV.						BY	DATE
DESIGN		AJS		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN		AJS					
CHECKED		<i>GP</i>		DRAWING NO.		REV. A	
MFG. APPR.		<i>BE</i>		<b>D4425</b>		SHEET 1 OF 1	
APPROVED		<i>MLJ</i>		TITLE		SCALE	
DE APPR.		<i>MLJ</i>		<b>SPACER</b>		NTS	
DATE		11.07.06		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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